






Blue

## Work Order ID 53347





Page 1

November 2, 2009 10:40:59 AM

Item ID: D2891-1 Accept  Setup Start   
 Revision ID: A1 Stop   
 Item Name: 2.25 Support  
 Start Date: 02/11/2009 Start Qty: 12.00  Cust Item ID:  
 Required Date: 13/11/2009 Req'd Qty: 12.00  Customer:

Reference:

Approvals: Process Plan: PL Date: 09/11/2 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2891	Rev A1								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA046 Tumble &amp; Deburr

mt 09/11/04/SL  
09/11/05

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mt 09/11/04/SL  
09/11/05

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S.F. 09/11/06

12

0

# Work Order ID 53347

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Page 2

Item ID: D2891-1

Accept



Setup Start



Revision ID: A1

Stop



Item Name: 2.25 Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125  SprayPaint Spray Painting	Spray Painting per QSI005 4.2  Memo Prime B <u>110918</u> Spray Paint Delfleet Blue B <u>113171</u> Clear Delfleet B <u>113088</u>	0.00  0.00				<u>ml</u>	<u>09</u>	<u>11</u>	<u>24</u>
135  QC Quality Control	QC14- Inspect Spray Paint  Memo	0.00  0.00				<u>BT</u>	<u>09</u>	<u>11-25</u>	<u>(12)</u>
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>X-tubes</u> <u>ASBY</u>  Memo	0.00  0.00				<u>ml</u>	<u>09</u>	<u>11</u>	<u>25 (12)</u>

# Work Order ID 53347

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Page 3

Item ID: D2891-1

Accept



Setup Start



Revision ID: A1

Stop



Item Name: 2.25 Support

Start Date: 02/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/25

AL 09-11-25

# Picklist Print

November 2, 2009 10:41:04 AM

Page 1

Work Order ID: 53347

Parent Item: D2891-1RevA1

Parent Item Name: 2.25 Support

Comments:

Start Date: 02/11/2009

Required Date: 13/11/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK076RevA		Manufactured	No			110	Each	10.0000	6.0000			

D2891-1 TURNING DETAIL

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT                                              10

42244                                              1

43384                                              4

51184                                              5

52266

mt  
29/11/05

6 blank

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	533217
<b>Description:</b> Ø2.250 Support		<b>Part Number:</b>	D2891-1
<b>Inspection Dwg:</b> D2891		<b>Rev:</b> A1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.190	.191	.191	.191	.189
AB	0.240	0.260		.250	.252	.250	.250	.249
AC	0.115	0.150		.125	.125	.125	.125	.126
AD	0.040	0.060		.049	.050	.050	.048	.050
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		R.250	R.250	R.250	R.250	.250
AG	0.290	0.310		.309	.310	.298	.306	.310
AH	0.115	0.150		.139	.138	.137	.138	.137
AI	0.454	0.474		.465	.465	.465	.465	.465
AJ	2.779	2.789		2.783	2.783	2.783	2.783	2.784
AK	0.240	0.260		R.250	R.250	R.250	R.250	.250
AL	1.002	1.042		1.037	1.042	1.037	1.040	1.035
AM	0.053	0.073		R.063	R.063	R.063	R.063	.063
AN	0.257	0.262		.258	.258	.258	.258	.257
AO	1.663	1.683		1.674	1.674	1.675	1.674	1.673
AP	0.053	0.073		R.063	R.063	R.063	R.063	.063
AQ	0.022	0.042		R.032	R.032	R.032	R.032	.032
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>mmf / JH</i>	Date: 09/11/05
Audited by: <i>JS</i>	Date: 09/11/06
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Ø2.250 Support</b>		<b>Part Number:</b>	<b>D2891-1</b>
<b>Inspection Dwg: D2891</b>	<b>Rev: A1</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	✓6	✓7	✓8	✓9	✓10
<b>HAAS Section</b>								
AA	0.188	0.193		.189	.189	.189	.189	.189
AB	0.240	0.260		.250	.251	.250	.250	.249
AC	0.115	0.150		.126	.125	.125	.125	.126
AD	0.040	0.060		.049	.050	.050	.050	.049
AE	0.010	0.020		.010	.010	.010	.010	.010
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290	0.310		.310	.310	.310	.310	.310
AH	0.115	0.150		.137	.137	.137	.137	.137
AI	0.454	0.474		.465	.465	.465	.464	.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.035	1.033	1.038	1.040	1.037
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.262		.257	.257	.257	.257	.257
AO	1.663	1.683		1.674	1.675	1.673	1.672	1.672
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042		.032	.032	.032	.032	.032
AR								
AS								
AT								
<b>Accept/Reject</b>								

**Measured by:** SL **Date:** 09/11/05

**Audited by:** SL **Date:** 09/11/05

**Prototype Approval:**  **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description: Ø2.250 Support</b>		<b>Part Number:</b>	<b>D2891-1</b>
<b>Inspection Dwg: D2891</b>		<b>Rev: A1</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	3	4	5
<b>HAAS Section</b>								
AA	0.188	0.193		.189	.189			
AB	0.240	0.260		.250	.249			
AC	0.115	0.150		.125	.125			
AD	0.040	0.060		.050	.050			
AE	0.010	0.020		.010	.010			
AF	0.240	0.260		.250	.250			
AG	0.290	0.310		.310	.310			
AH	0.115	0.150		.137	.137			
AI	0.454	0.474		.470	.469			
AJ	2.779	2.789		2.784	2.784			
AK	0.240	0.260		.250	.250			
AL	1.002	1.042		1.038	1.037			
AM	0.053	0.073		.063	.063			
AN	0.257	0.262		.257	.257			
AO	1.663	1.683		1.674	1.674			
AP	0.053	0.073		.063	.063			
AQ	0.022	0.042		.032	.032			
AR								
AS								
AT								
<b>Accept/Reject</b>								

**Measured by:** JL **Date:** 09/11/05

**Audited by:** SP **Date:** 09/11/06

**Prototype Approval:**  **Date:**

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

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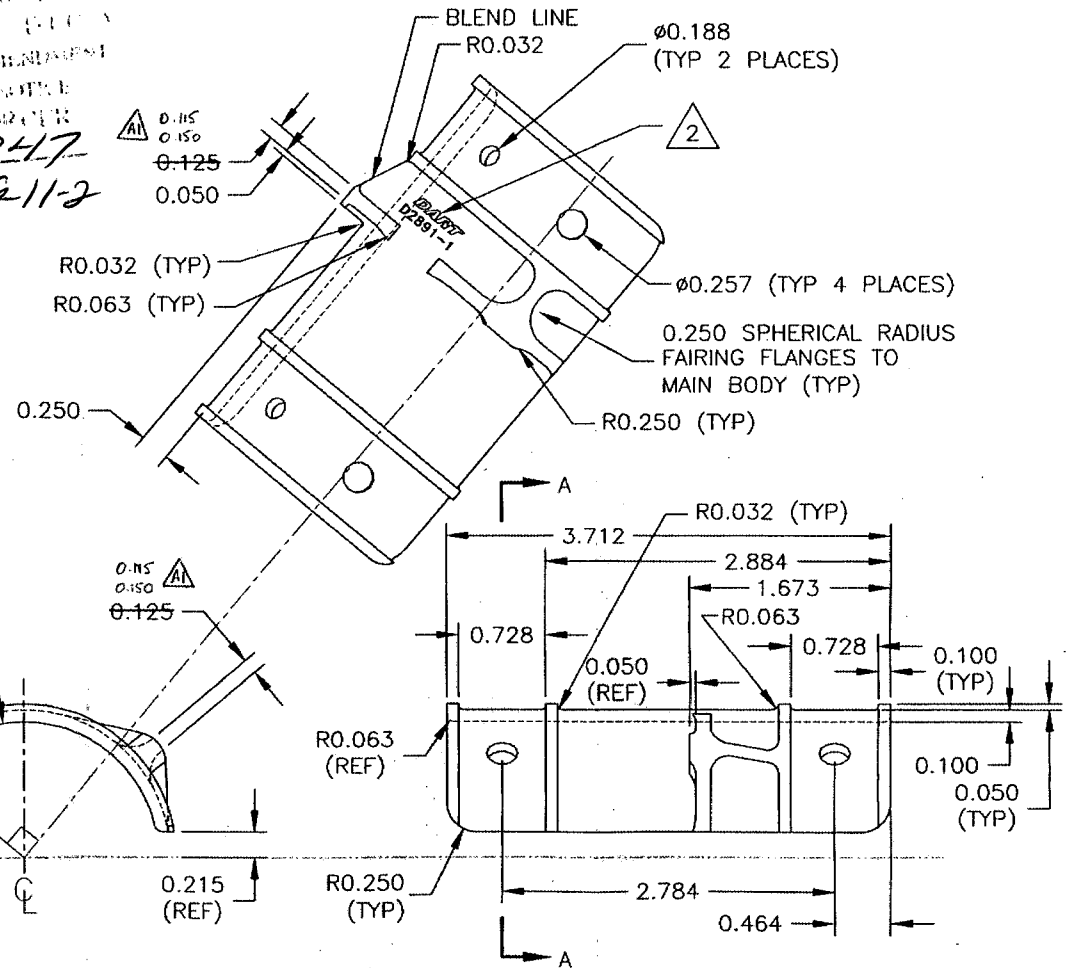
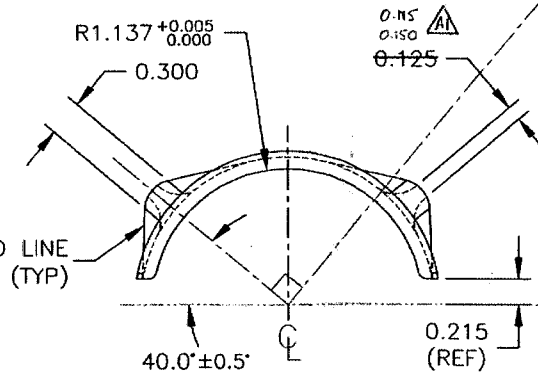
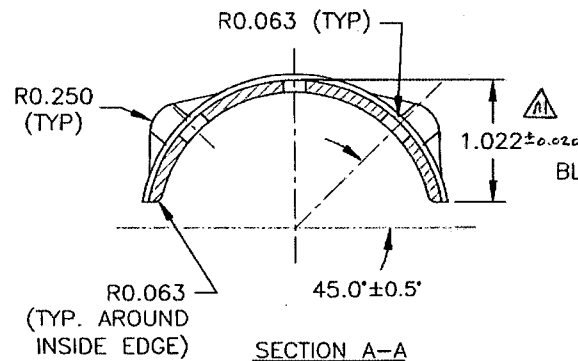
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WORK ORDER  
NO. 53347  
B10911-2

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



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AI	CP	02.01.13	UPDATE DIMS AS MANUFACTURED
A		00.11.17	NEW ISSUE
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	00.11.17	DRAWING NO.	D2891
		TITLE	02.250 SUPPORT
		REV. A	SHEET 1 OF 1
		SCALE	1:1

**DART** DART AEROSPACE LTD.  
MARKHAM, ONTARIO, CANADA